



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C3-13-4-2

Job Sheet 193759



REPRINT

Part No: C3-13-4-2

Job Qty: 10 pcs

Part Name: Keeperless Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 6/3/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG C3-13-4-2 REV.4 IPP REV A 18.07.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194926



Part: C3-13-4-2

Job No: 193759

Serial No/Batch: S194926

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 09/11/19

See Attached

ng

Workcenter/Supplier	Sign-off
Workcenter / Supplier Lead Time	

0 NV5000 - 1

0 NV5000 - 2

0 QC 2 - 1

QC 2 - 12

QC 2 - 14

QC 2 - 17

QC 2 - 19

QC 2 - 2

QC 2 - 20

QC 2 - 22

QC 2 - 23

QC 2 - 25

QC 2 - 32

QC 2 - 33

QC 2 - 35

QC 2 - 39

QC 2 - 4

QC 2 - 40

QC 2 - 44

QC 2 - 45

QC 2 - 48

QC 2 - 49

QC 2 - 50

QC 2 - 51

QC 2 - 52

QC 2 - 57

QC 2 - 62

QC 2 - 63

QC 2 - 8

QC 2 - 66

QC 2 - 64

CRIP

NCR
raised,
Holly & Kim
informed

SEP 11 2019

DAS
81
9-89

130 QC 8	10 pcs	6/3/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
135 Outsource - 1 - Heat Treat	10 pcs	6/3/19		MEI001-VC	15
136 Packaging 2-1 - Receive - B4B	10 pcs	6/3/19	0.00 0.00	Packaging 2 - 1 - B4B	
<i>See Attached</i>				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	

Plex 8/19/19 10:07 AM Dart.Guerin.Kimberley

<i>See attached</i>				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
137	QC 6	10 pcs	6/3/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
148	Outsource - 15 - Nickel Plate	10 pcs	6/3/19		GRO002-VC 5 <i>2019-08-19</i>
150	Packaging 2-2 - Receive - B4B	10 pcs	6/3/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
160	QC 6	10 pcs	6/3/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
210	Packaging 3-1 - Stock - B4B	10 pcs	6/3/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B

SEP 10 2019

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	10 pcs	6/3/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) - 1-Machine as per folio FC495 FOLIO REV: _____
 Descriptions: DWG REV: _____ 2-Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

135 - Outsource process - Heat Treat - 1-Issue P/O to METCORE; P/O _____ RC 40-44 2-Bead blast 3--
 Material type steel; 4- Certificate of Conformity is required

136 - (Receive & Inspect for Damage & Mat'l Certs)

137 - QC6- All purchased or subcontracted products

148 - Outside Processing - Nickel Plate -Issue P/O; 44286 -All noncertified parts specifying a finish of Nickel
 Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type
 4/5, SC0-SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if
 noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is
 required

150 - Receive & Inspect for Damage & Mat'l Certs

160 - QC6- All purchased or subcontracted products

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.500X2.250	AISI 4140 / 4142 Steel Bar 1.500 T x 2.250 W	3.2100 ft (.321 ea)	110-NV5000 - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-NV5000 - 1	MT-4140-B-1.500X2.250	3	0	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Canada

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C3-13-4-2

Job Sheet 193759



Part No: C3-13-4-2

Job Qty: 10 pcs

Part Name: Keeperless Adapter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Due Date: 6/3/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG C3-13-4-2 REV.4 IPP REV A 18.07.24 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	NV5000 - 1	10 pcs	6/3/19		0.00	5.00	NV5000 - 1		S.C.L.
							NV5000 - 2		
120	QC 2	10 pcs	6/3/19		0.00	0.00	QC 2 - 1		S.C.L. 19-07-25
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
130	QC 8	10 pcs	6/3/19		0.00	0.00	QC 8 - 12		m/L 19/07/11
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		

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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194926



Part: C3-13-4-2

Job No: 193759

Serial No/Batch: S194926

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 06/29/13

Plex 4/22/19 12:23 PM Dart.Renwick.Jennife

				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
135	Outsource - 1 - Heat Treat	10 pcs	6/3/19	ME001-VC AFLOC25	2019-07-11
148	Outsource - 15 - Nickel Plate	10 pcs	6/3/19	GRO002-VC	5
150	Packaging 2-1 - Receive - B4B	10 pcs	6/3/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
160	QC 6	10 pcs	6/3/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
210	Packaging 3-1 - Stock - B4B	10 pcs	6/3/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Plex 4/22/19 12:23 PM Dart.Renwick.Jennife

DAS
61
9-89

Ble Packaging

137 Qc6

[Signature] JUL 26 2019

				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	10 pcs	6/3/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) - 1-Machine as per folio FC495 FOLIO REV: AA

Descriptions: DWG REV: 4 2-Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

135 - Outsource process - Heat Treat - 1-Issue P/O to METCORE; P/O 43981 RC 40-44 2-Bead blast 3--
Material type steel; 4- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER METCORE to ship
directly to GROUPE ALTECH ***

148 - Outside Processing - Nickel Plate -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class
2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required

150 - Receive & Inspect for Damage & Mat'l Certs

160 - QC6- All purchased or subcontracted products

210 - Identify as per dwg & Stock Location: _____

220 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1.500X2.250	AISI 4140 / 4142 Steel Bar 1.500 T x 2.250 W	3.2100 ft (.321 ea)	110-NV5000 - 1	<u>5124611</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-NV5000 - 1	MT-4140-B-1.500X2.250	3	4	0

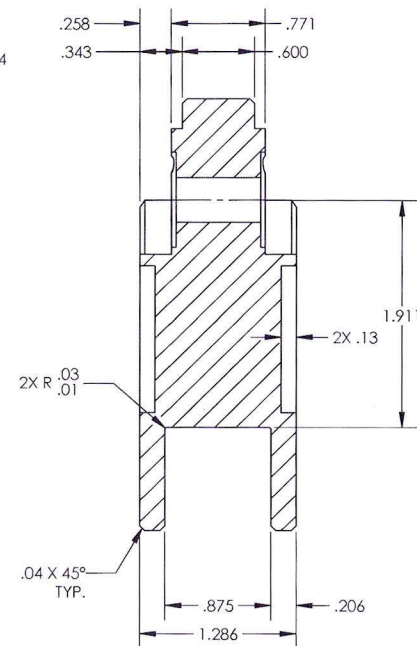
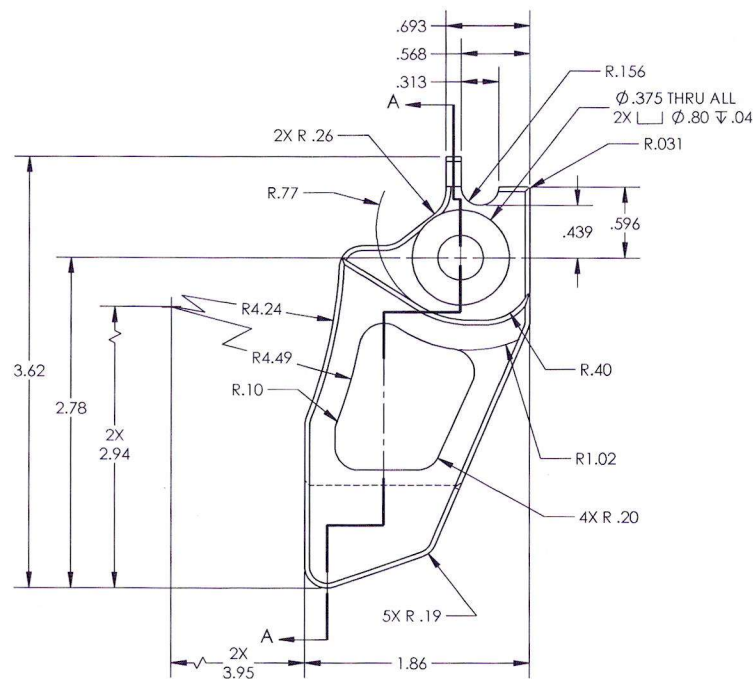
Part Specifications	
Specifications could not be found.	

MAT
used
3.369'

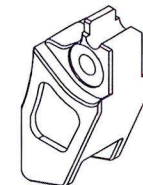
Plex 4/22/19 12:23 PM Dart.Renwick.Jennifer

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM.	6/21/2002	DPD	
3	15-0195	CHD RADIUS WAS R.03 IS R.03 - .01, ADDED NOTE 3, ADDED HEAT TREAT HRC 40-44.	8/5/2015	RJC	JAG
4	17-0140	UPDATED TO NEW DRAFTING STANDARD, CHD DIM'S WAS .784 IS .771, WAS 2X .251 IS .258, WAS 2X .343 IS .343.	6/16/2017	RJC	SM



SECTION A-A



- NOTES:
1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.
 2. USE DXF PROFILE FOR PART CONTOURS.
 3. MACHINE ENGRAVE BATCH NUMBER.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C3-13-4-2	1	KEEPERLESS ADAPTOR C3-HOOK	4140/4142	

DART AEROSPACE	
TITLE KEEPERLESS ADAPTOR C3-HOOK	
DWG NO.	C3-13-4-2
REV	4
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT HRC 40-44	DIMENSIONS ARE IN INCHES
FRACTIONAL SEE NOTE 1	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125
SPEC	1. BREAK ALL SHARP EDGES
	.015 x 45° OR .015R
DRAWN BY: RJC 06/16/2017	2. DIMENSIONAL LIMITS APPLY
CHECKED: DD 06/16/2017	AFTER PLATING
OPPS APPR: AA 06/20/2017	3. INTERPRET DIM AND TOL PER
QA APPR: JL 06/21/2017	ASME Y14.5M-2009
APPROVED: SM 06/21/2017	USED ON MODEL
SCALE 1:1	DATE 6/16/2017
SHEET 1 OF 1	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043981



Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S 1R4 Canada
Phone: 866 257 6395

Attention: Ananth, Nimmy

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043981

PO Date: 7/11/19

Due Date: 7/19/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196111	RB6798838-2	Drift Housing 1-Issue P/O; RC 48-52 2-Bead blast 3-Material type; O1 4- Certificate of Conformity is required	Firmed	-	7/19/19	5 pcs	0 pcs	5 pcs	\$15.00/pcs	\$75.00
2	196110	RB6798838-1	Drift 1-Issue P/O; RC 48-52 2-Bead blast 3-Material type; O1 4- Certificate of Conformity is required	Firmed	-	7/19/19	6 pcs	0 pcs	6 pcs	\$12.50/pcs	\$75.00
3	197105	RB T102137- 111-113	Clevis 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Certificate of Conformity is required	Firmed	-	7/19/19	4 pcs	0 pcs	4 pcs	\$42.50/pcs	\$170.00



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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043981



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193759	C3-13-4-2	Keeperless Adapter Outsource process - Heat Treat - 1-Issue P/O _____ RC 40-44 2-Bead blast 3--Material type 4140/41 42 4- Certificate of Conformity is required.	Firmed	-	7/19/19	10 pcs	0 pcs	10 pcs	\$7.50/pcs	\$75.00
Grand Total:											\$395.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/25/19 2:07 PM Dart.Guerin.Kimberley

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 164993
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
POHB043981				

Quantity	Part No. / Part Name / Part Description	Pounds
10 PCS	MATERIAL 4140 SANDBLAST AND HEAT TREAT TO 40-44RC C OF C, PRT# C3-13-4-2, JOB# 193759	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

10

Pounds Shipped:

11.00

44Rc
7-18-19

F - 8131 7835 0312

RECEIVED

JUL 25 2019

DART AEROSPACE LTD.

Order No.: 168098

Shipped Complete

Quantity Shipped:

10.00

Received By:

Date:

Pounds Shipped:

11.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 07/12/2019

Certification

Date: 18/07/2019

Entry Date: 12/07/2019

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: POHB043981 ✓

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

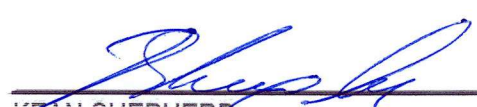
We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
10	10 PCS MATERIAL 4140 SANDBLAST AND HEAT TREAT TO 40-44RC C OF C, PRT# C3-13-4-2, JOB# 193759 ✓	11

Insp. Type	Scale	Minimum	Maximum	Number	Other
<u>Customer Requirements:</u>					
					DAS 61 9-89

Results:Harden ROCKWE 40. 44. 44. TESTED AS PER SAMPLING PLAN
HEAT TREATED TO 44RC AS PER CUST REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.


KEANE SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044286**



REVISED

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044286

PO Date: 8/19/19

Due Date: 8/27/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	193759	C3-13-4-2	Keeperless Adapter Outside Processing - Nickel Plate -Issue P/O; -All noncertified parts specifying a finish of Nickel Plating per QQ-N-290, or parts with drawings that are missing a specification Can be Nickel Plated per ASTM B733 Type 4/5, SC0- SC4 or MIL-C-26074 Class 1/2 -Material type; 4140 -Heat treat must be carried out to specified hardness if noted on the drawing. -Plating thickness must be carried out as specified on the drawing. -Certificate of Conformity is required	Firmed	-	8/27/19	9 pcs	0 pcs	9 pcs	\$40.00/pcs	\$360.00

X9

SEP 10 2019

DP

5194926

Grand Total: \$360.00

[Signature]



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044286



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/10/19 2:28 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021666-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

021666 - 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
05-Sep-2019		Jigar Patel		POHB044286				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C3-13-4-2 Rev.	C3-13-4-2 SCOTCH WHITE E-NIC STEEL 200 [E-NICKEL STEEL 200] ASTM B733 TYPE 4 / 5, SC0 - SC4 OR MIL-C-26074 CLASS 1 / 2 0.0004-0.0006 THICKNESS BAKE AFTER PLATING	E-NICKEL STEEL CH	9	9	0	0	0
2	BAKING CHARGE Rev.	BAKING CHARGE 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	1	1	0	0	0
3	SANDBLAST Rev.	SANDBLAST SANDBLAST	SANDBLAST MIN-CHG	1	1	0	0	0

RECEIVED
SEP 09 2019
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

1 Box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jg Jky

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

cm 619
7:45

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only ☐

Job: <u>193759</u> Part No. <u>C3-13-4-2</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐																															
Date : SEP 11 2019		Sequence #: <u>QC-6</u>		QTY Affected : <u>9 of 9</u>		MRB (OSI042) 68 9-89 SEP 11 2019																													
Description Work Order Deviation Parts returned from re-work nickel plating. Part is still blotchy and unevenly plated. DAS 81 9-89				Disposition <u>-RETURN FOR REWORK</u> SCRAP				Completed By Lead hand / Supervisor QC / QA Coordinator DAS 68 9-89 SEP 30 2019																											
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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